



Dart Hawkesbury
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D4634-141
Job Sheet 167074-B



Part No: D4634-141

Job Qty: 1 ea

Part Name: Fwd, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/23/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/23/17	0.00	0.00	Start up container	2017-12-13, 28
100	HandThermo	1 pcs		11/23/17	0.00	1.65	HandFinish4	17/12/14
110	Small Fab	1 pcs		11/24/17	0.00	1.47	Small Fab	17/12/14
120	QC	1 pcs		11/24/17	0.00	0.00	QC5	17-12-27
130	Packaging	1 pcs		11/24/17	0.00	0.00	Packaging3	
140	QC21-SA	1 Ea		11/24/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138649 Expiry Date 18/01/29 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-1 <u>5021473</u>	1	3	0	0
	- D4636-5 <u>5021471</u>	1	43	0	0
	- D4647-5 <u>5021470</u>	1	2	0	0
	- D4664-5 <u>5021469</u>	6	39	0	0
	- D4712-1 <u>5021468</u>	1	4	0	0
	- D4732-15 <u>5021466</u>	1	2	0	0
	- D4732-19 <u>5021463</u>	1	1	0	0
	- D5021-1 <u>5021461</u>	1	2	0	0
	- MPNY-750S-9-C <u>5021460</u>	7	570	0	0
	- MS20426AD3-4 <u>5021459</u>	4	5,055	0	0
	- MS20426AD4-6 <u>5021458</u>	2	2,797	0	0
	MS21059L08 <u>504457</u>	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____		DISPOSITION Mfg Date: 12/13/17 Job No: 167074 – B		AGAINST DEPARTMENT/PROCESS					
 Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com S021500 Fwd, Center Ceiling Replacement Panel Assembly PART NO: D4634 – 141 Revision: Start up Operation Operation: Start up Operation Change No:		Skid-tube ☐ Machining ☐ thermoforming ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		Engineering ☐ Quality ☐ Other ☐	
		QTY Effective : _____				MRB (QSI042) Approval			
		Disposition				Completed By			
		(Empty space for disposition details)				Lead hand / Supervisor Approval Verification			
(Empty space for disposition details)				QC / QA Coordinator Approval					
DART AEROSPACE S021500 Fwd, Center Ceiling Replacement Panel Assembly		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		Temperature/Cure ☐ Set-up ☐ DM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Not Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Marks/Chatter ☐ OTHER : _____							